

Work Order ID 76039

November-03-11 10:40:36 AM

76039

Page 1

Item ID: D3272-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Step

Stop

NS2

Start Date: 03/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/11/03

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100

100

Large Fab

0.00

11/11/18

10 Ø

Large Fab

Memo

0.00

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110

110

QC6- Inspect dimensions to drawing

0.00

11/11/18

QC

Quality Control

Memo

0.00

(X10)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	
	QC:	Date:	SPC (Y/N):	Date:			*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Packaging	Identify as per dwg & Stock Location: <i>11A</i>	0.00	<i>11.11.18</i>			<i>10</i>	<i>0</i>		
Packaging	Memo	0.00							

130 *130* QC	QC21- Final Inspection - Work Order Release	0.00	<i>11/11/2018</i>
Quality Control	Memo	0.00	

11/11/18
11/11/18

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Picklist Print

November-03-11 10:40:40 AM

Page 1

Work Order ID: 76039

76039
D3272-1

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 03/11/2011

Required Date: 01/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	58.0200	1	10		11.11.18	**

D2622-120C

Step Extrusion

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	HALL	48.32	
	64409	6	
	68293	0.5	
	72131	41.82	10
	WA	9.7	
	46910	2	
	66970	7.7	

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NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 76035 MC-J
 11/11/03

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Dart Aerospace Ltd

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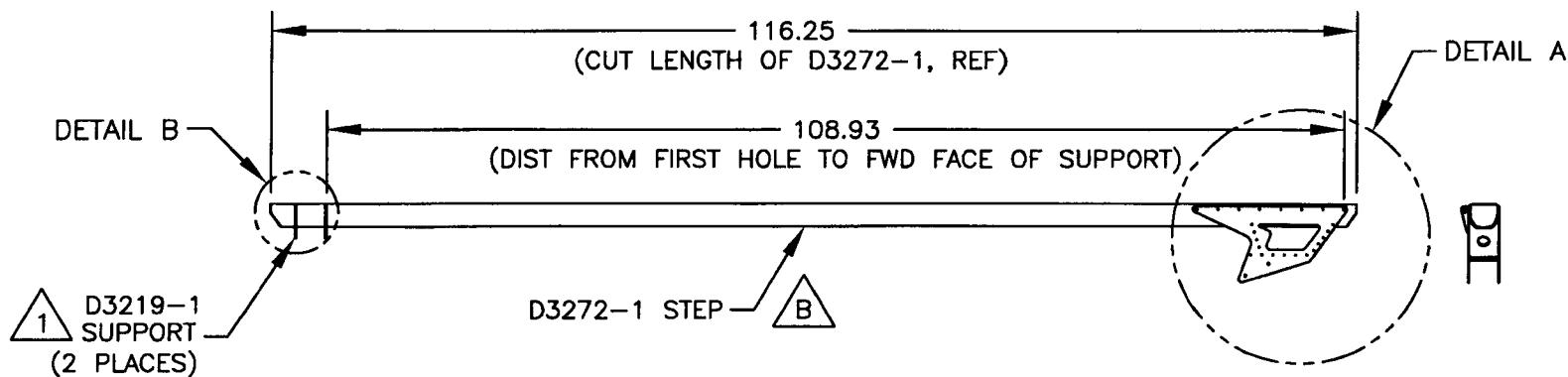
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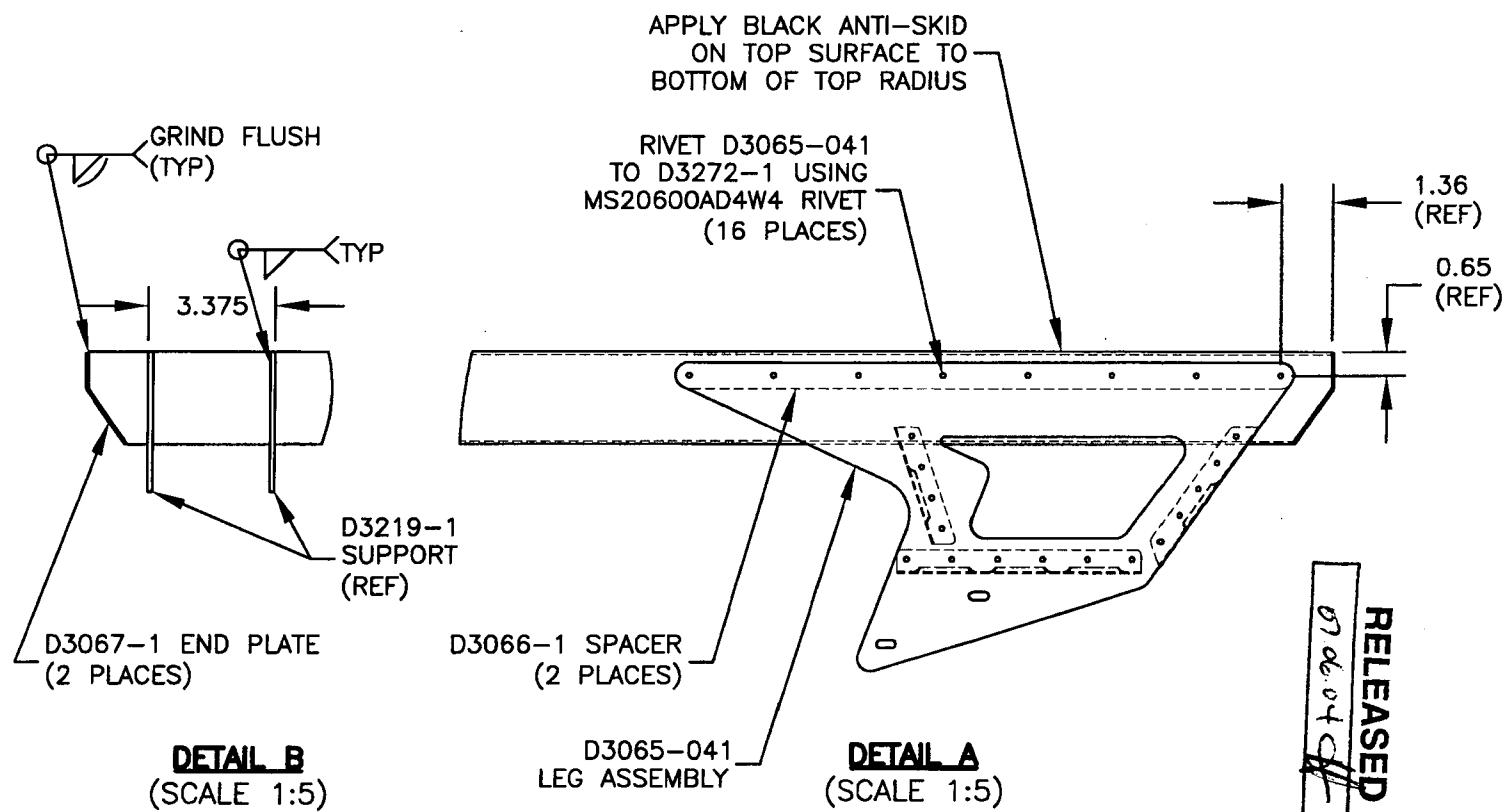
NOTE: Date & initial all entries

DART

DESIGN	90	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.
DATE	07.05.18			D3272
TITLE				STEP ASSEMBLY, HI LONG
SHEET 2 OF 3				REV. B
SCALE				1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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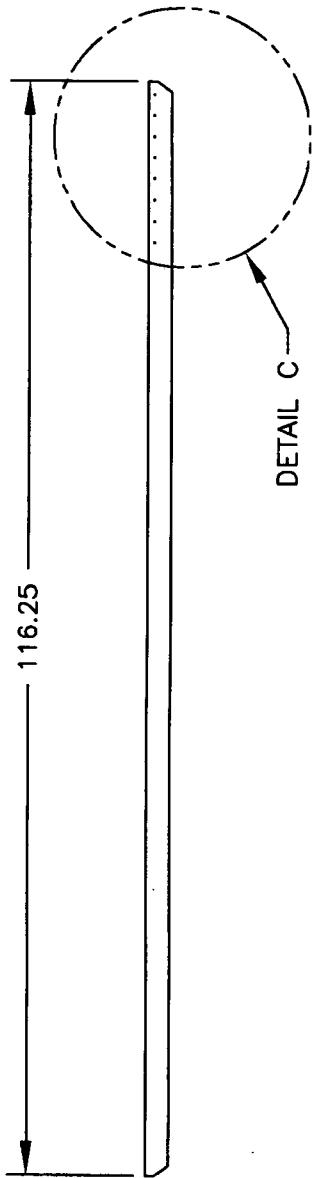
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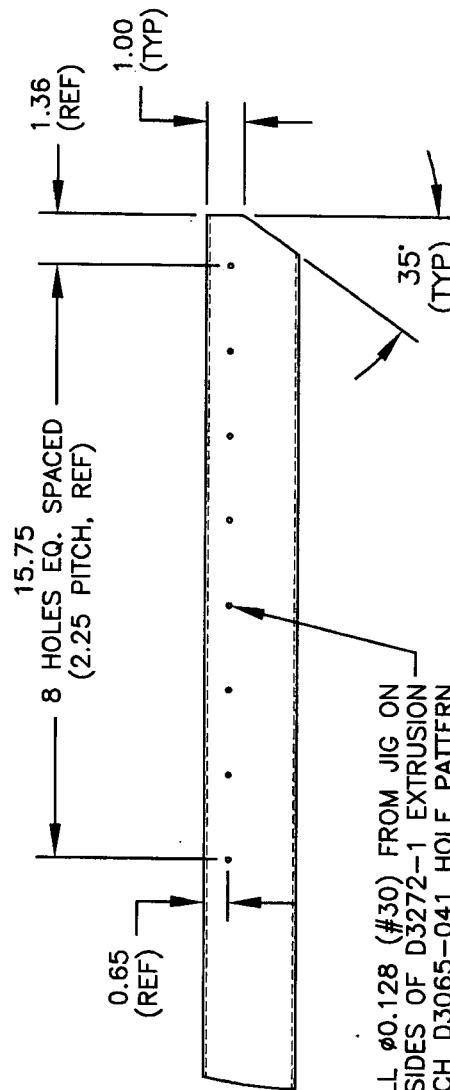
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DART

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



△ **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL #0.128 (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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